



NOTES:

1. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL
2. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
3. USE TIG TUNGSTEN INERT GAS WELD.
4. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
5. BEFORE WELDING ITEM #2 TO ITEM #1, WELD ITEM #3 (2) TO ITEM #1, THEN DRILL AND REAM ITEM #3 (2) AS SHOWN
6. DIMENSIONS IN [] ARE MILLIMETERS

SECTION A - A

6	P4102010103-210104	P1 ALIGNMENT FINGER	304 SST	1
5		#8 - 32 X 3/32 LG. SET SCREW	SST	2
4		NEEDLE BEARING MC GILL CAT. #6NAS1218	SST	2
3	P4102010103-210103	P1 VACUUM FLANGE PIVOT SUPPORT		2
2	P4102010103-210102	P1 BELLOWS FLANGE	304 SST	1
1	P4102010103-210101	P1 UPPER VACUUM FLANGE	304 SST	1

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
6	P4102010103-210104	P1 ALIGNMENT FINGER	304 SST	1
5		#8 - 32 X 3/32 LG. SET SCREW	SST	2
4		NEEDLE BEARING MC GILL CAT. #6NAS1218	SST	2
3	P4102010103-210103	P1 VACUUM FLANGE PIVOT SUPPORT		2
2	P4102010103-210102	P1 BELLOWS FLANGE	304 SST	1
1	P4102010103-210101	P1 UPPER VACUUM FLANGE	304 SST	1

LOG NUMBER	DATE	DESIGNER	DATE	TITLE
A13211	8/3/92	D. SHU	6/15/93	ADVANCED PHOTON SOURCE
DRAWN BY	DATE	CHECKED BY	DATE	
MUSCIA	8/3/92	T.M. KUZAY	6/15/93	
DESIGNED BY	DATE	PROJECT MGR.	DATE	
MUSCIA	8/3/92			
RESPONSIBLE ENGINEER	DATE	APPROVED/RELEASED	DATE	
D. SHU	6/15/93			
MATERIAL	DATE	SCALE	SHEET	DRAWING NUMBER
SEE PARTS LIST	6/15/93	1:1	1 of 1	P4102010103-210100-01